

011373



Dart Aerospace Ltd.
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K10003**Job Sheet 193854****Part No:** K10003**Job Qty:** 4 pcs**Part Name:** Saddle**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/23/19**Job Tracking No:****Due Date:** 5/10/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV H IPP: 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF IPP : J 06-07-25 As per DSI 9344
JLM IPP : K 06.11.17 Per K10003 Rev C KJ IPP : L 07.01.12 Document Record for copying bluefile rmv KJ IPP
Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified: IPP N 09.01.27 DSI 9418 rev B EC verified:DD IPP
Rev:O 11.03.11 per dsi9536 DD ver:EC IPP REV:P 12.01.23 AS PER ECN11-684 VER:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		5/10/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
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							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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Container No: S209241**Part:** K10003**Job No:** 193854**Serial No/Batch:** S209241**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/27/18

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					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	4 pcs	5/10/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
130 Packaging 3-1 - Stock - B4B	4 pcs	5/10/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	4 pcs	5/10/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	4 pcs	5/10/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 110 - (Pick Kit) AN960JD616 EQUIVALENT TO NAS1149D0663J

Descriptions: 120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location:_____)

135 - (Document Control) Create White labels only per PPP K10003

140 - (QC21- Final Inspection - Work Order Release)

DAG
21
SEP 05 2019

DAG
21
SEP 05 2019

MJD
9/5/2019

Max B.

AL

DAS
21 SEP 05 2019

DAS
21 SEP 05 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-51A	Bolt	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	517416312/5158580X 30
AN4-6A	Bolt	64 Ea (16 ea)	110-Packaging 1 - Pick Kit	5149813
AN4C46A	Bolt	16 Ea (4 ea)	110-Packaging 1 - Pick Kit	5161343
AN6-12A	Bolt	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	5156443
D2570	Bushing	96 pcs (24 ea)	110-Packaging 1 - Pick Kit	5193921X9015196 295X6
D2571	Saddle, Fwd, Out	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193921
D2572	Saddle, Fwd, In	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193921
D2573	Saddle, Aft, Out	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193921
D2574	Saddle, Aft, In	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193921
D2747	Set Screw	16 pcs (4 ea)	110-Packaging 1 - Pick Kit	5176125
D2876	Saddle Spacer	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5178570
D2877	Saddle Spacer	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5178527
D3405-041	Ground Handling Lug	4 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5207250 ✓
D3405-043	Ground Handling Lug	4 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5206154 ✓
D3407-041	Tow Ring	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5175517
D3417-5	Washer	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5163235
D3456-1	Washer	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5199355
D3533-1	Set Screw	8 pcs (2 ea)	110-Packaging 1 - Pick Kit	5203845
MS21042L4	Nut	96 Ea (24 ea)	110-Packaging 1 - Pick Kit	5203845
MS21043-4	Nut	20 Ea (5 ea)	110-Packaging 1 - Pick Kit	5198136
NAS1149D0463J	Washer	128 Ea (32 ea)	110-Packaging 1 - Pick Kit	5196202/5205205
NAS1149D0663J	Washer	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	5161575

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-51A	32	220	0
	AN4-6A	64	944	0
	AN4C46A	16	127	0
	AN6-12A	32	319	0
	D2570	96	309	0
	D2571	4	30	0
	D2572	4	26	0
	D2573	4	5	0
	D2574	4	1	0
	D2747	16	152	0
	D2876	8	29	0
	D2877	8	32	0
	D3405-041	4	4	0
	D3405-043	4	4	0
	D3407-041	4	13	0
	D3417-5	8	99	0
	D3456-1	4	139	0
	D3533-1	8	161	0
	MS21042L4	96	3,678	0
	MS21043-4	20	1,375	0
	NAS1149D0463J	128	4,486	0
	NAS1149D0663J	32	1,304	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐																													
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																	
Description Work Order Deviation				Disposition																																			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Completed By				Lead hand / Supervisor																																			
QC / QA Coordinator				QC / QA Coordinator																																			

5.3 Skidtube Installations with Lightweight Thru-Bolt Wearplates

Item	634-113	634-145	634-147	634-011	Part Number	Description
					D205-634-113	SKIDTUBE INSTALLATION (STANDARD) WITH THRU BOLT WEARPLATES
	1	X			D205-634-145	REPLACEMENT SKIDTUBE WITH THRU BOLT WEARPLATES
			X		D205-634-147	THRU BOLT WEARPLATE KIT
	1				D205-641-011	GROUND HANDLING KIT
1		1			D2580-049	205 SKIDTUBE ASSEMBLY (STANDARD)
2A		8			D2594-1	* PLUG
2B		8			D2594-3	* O-RING
3		1			D2855	* AFT CAP
4		2			AN3-5A	* BOLT
5		2			NAS1149D0332J	* WASHER (AN960JD10L)
13		2			ALS4-1032-225	* INSERT
14B		1	1		D5061-1	* FWD WEARPLATE
15B		1	1		D5061-3	* AFT WEARPLATE
16		8	8		AN4-45A	* BOLT
17		16	16		D2570	* BUSHING
18		8	8		MS21042L4	* NUT (OR MS21042-4)
19			4		D2579	* SPACER
20	1				D2571	SADDLE, FWD OUTSIDE
21	1				D2572	SADDLE, FWD INSIDE
22	1				D2573	SADDLE, AFT OUTSIDE
23	1				D2574	SADDLE, AFT INSIDE
24	8				AN4-51A	BOLT
25	16				D2570	BUSHINGS
26	8				MS21042L4	NUT (OR MS21042-4)
27	8				AN6-12A	BOLT
28	8				NAS1149D0668J	WASHER (AN960JD616)
29	16				AN4-6A	BOLT
30	32				NAS1149D0463J	WASHER (AN960JD416)
31	16				MS21042L4	NUT (OR MS21042-4)
32	4				D2747	SET SCREW
33	2				D3533-1	SET SCREW
40	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1				D3456-1	WASHER
43	1				MS21043-4	NUT
44	2				D3417-5	WASHER
50				1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51				1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52				4	AN4C46A	BOLT
53				4	D2570	BUSHING
54				4	MS21043-4	NUT (OR MS21042-4)
60	2				D2876	SADDLE SPACER
61	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-049 ASSEMBLY ABOVE